

ABSTRACT OF THE DISCLOSURE

A carpet in tile or roll form is produced using an open mesh reinforced foam layer with foam nodules. The carpet is produced having a primary backing through which carpet fiber bundles are tufted and a precoat layer which locks the tufts in place to prevent easy extraction of the fibers so that a tufted face and a relatively smooth back face are provided. The foam layer with foam nodules is brought into intimate contact with the relatively smooth back face, and is substantially permanently adhered to it producing a carpet tile or roll that is substantially prevented from curling or doming (or they are significantly reduced) and may be installed without adhesive if desired. Adhering may be practiced by using a non-fused adhesive formulation which is subsequently fused at a low temperature (about 310°F or less), or by forcing the foam layer with foam nodules into contact with the carpet back while the hot melt backing is still in a fluid form, or by use of a thermoplastic layer between the carpet and foam sheet.

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